

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003029**Date Inspected:** 16-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C.G. Luang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Segments and Sub-assemblies**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Mahlon Lindenmuth, arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following:

QA Inspector, Lindenmuth, observed the work being performed in Bay 2 of the New OBG. ZPMC personnel were performing various functions related to the fabrication of the OBG Side Plates and Bottom Plates as well as the deck sections in the jig fixture. The fabrication performed includes but is not limited to the preparation of areas where temporary welds for strongbacks are located, bevel preparation and welding of the Complete Joint Penetration welds (CJP) on Side Plates and Bottom Plates, heat straightening of Side Plates and Bottom Plates.

South Jig Fixture:

*Segment 3AE- Caltrans QA Inspector, Lindenmuth, observed ZPMC personnel performing air carbon arc gouging on the Complete Joint Penetration weld joining 3AE-D6 to 3AE-C5. The gouging is being performed on order to remove discontinuities discovered by Ultrasonic Testing (UT) performed by ZPMC QC personnel. This is a first time repair on this joint. Magnetic Particle Testing (MT) will be performed by ZPMC QC after excavations have been cleaned by grinding.

*Segment 4BE- ZPMC personnel have excavated a portion of the CJP weld that joins the 4BE-D6 to the 4BE-C5. The excavation is approximately 275mm long and 10mm in depth. ABF Representative, Peter Shaw explained that discontinuities were discovered after UT was performed, by ZPMC QC, on the repair area. This will be a second time repair on the weld joint.

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Shop Welding:

*SEG026A-003- Caltrans QA Inspector, Lindenmuth, observed ZPMC personnel performing air carbon arc gouging on the root side of the CJP weld joining side plate SP564A to side plate SP524A. The backgouging is part of the Weld Procedure (WPS) and is performed after the welding of the face side is complete and the ceramic backing is removed.

Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lindenmuth,Mahlon	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
